

Date: Wednesday, 5/10/2006 9:20:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER BUSHING
Job Number : 27051	
Estimate Number : 10826	
P.O. Number : N/A	Part Number : D23273
This Issue : 5/10/2006 S.O. No. : N/A	Drawing Number : D2327 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 25823	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 5/30/2006 Qty: 50 Um: Each
Checked & Approved By : 06.05.10	
Comment : Est. F 05/11/02 Removed 303 SS KJ/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0375	304 SS ROUND BAR
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Comment: Qty.: 0.1641 f(s)/Unit Total : 8.2058 f(s)

Inventory

Material: AISI 303 Round Bar Ø0.375"

(M304R0.375)

Batch: M1002SS

MS 06/05/18

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

MS 06/05/18

S3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/05/18

S3

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

E 06/05/18

S3

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST38

06/05/23

(53)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/05/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/10/2006 9:20:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 27051

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

[Signature] 06/05/24 ⁵³

Job Completion



C 106/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

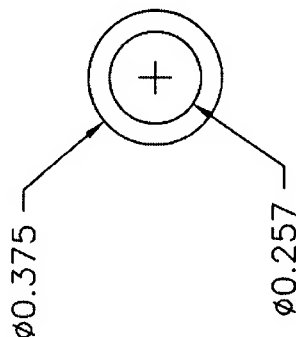
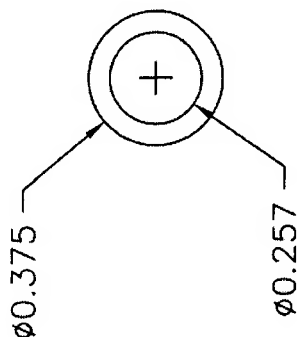
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

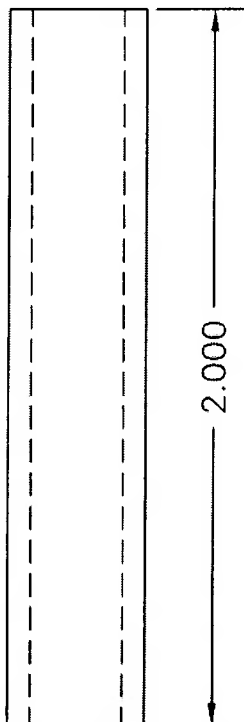


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2327	REV. C SHEET 1 OF 1
DATE 03.05.13		TITLE SPACER BUSHING	SCALE 2:1
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	

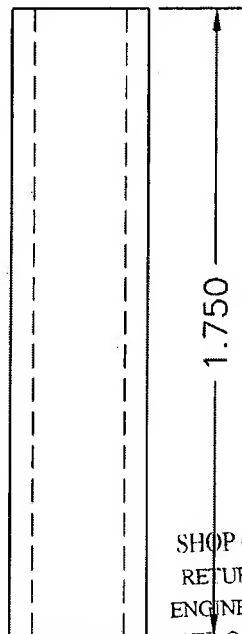
RELEASED
03.05.21 *[Signature]*



D2327-1



D2327-3



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 27051

NOTE:
1) MATERIAL: $\phi 0.375$ AISI 303 ROUND BAR (REF DART SPEC.
M303R0.375) OR $\phi 0.375$ AISI 304/316 SS 0.065
WALL SEAMLESS ROUND TUBING (REF. DART SPEC.
M304TR0.375W.065)

2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Date: Wednesday, 5/24/2006 11:36:16 AM

User: Chantal Lavoie

**INVENTORY ITEMS PICKED
FOR SLIP NUMBER 2489**

Project No. : N/A
Customer : Dart Helicopters Services
Part Number : D23273
Job Number : 27051

Drawing Number : D2327 REV C
Drawing Name : SPACER BUSHING
Due Date : / /
Qty : 53
Slip # : 2489

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 M304R0375 304 SS ROUND BAR Available 30.73	MAIN			100255		8.70	8.2058 f